

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018821**Date Inspected:** 26-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Yu Dong Ping
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

Trial Assembly

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 12AW to 12BW for repair due to mismatch, weld No. OBW12-001. The welder is identified as #040656. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR-1. The repair report is identified as WR17901.

SMAW in the 2G position for the OBG Segment 12BW weld No.SEG3005M-090. The welder is identified as #046704. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

SMAW in the 4F position for the OBG Segment 12BE weld No.DP3022-001-007/008. The welder is identified as #040270. ZPMC QC is identified as Mr. Liu Hue Jie. The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1.

WELDING INSPECTION REPORT

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Bay#8

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG bike path weld No.BK004-A5-064-112/115. The welder is identified as #069894. ZPMC QC is identified as Mr. Liu Fa Wen. The welding variables recorded by QC appear to comply with WPS-B-P-2213-B-U2.

FCAW in the 3F position for the OBG bike path weld No.BK004-A3-059-019/020. The welder is identified as #500479. ZPMC QC is identified as Mr. Liu Fa Wen. The welding variables recorded by QC appear to comply with WPS-B-T-2133-ESAB.

Bay#11

This QA Inspector observed the following work in progress:

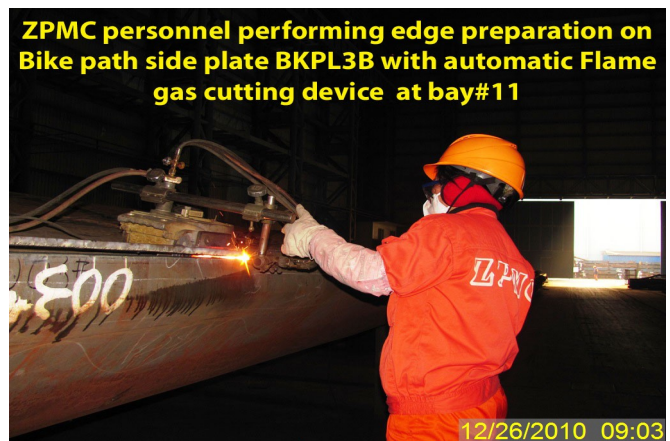
SMAW in the 1G position for the OBG bike path UT repair weld No.BK008-A1-002-044. The welder is identified as #044541. ZPMC QC is identified as Mr. Yu Dong Ping. The welding variables recorded by QC appear to comply with WPS-345-SMAW-1G(1F)-FCM-REPAIR-1.

Bay#10

This QA Inspector observed the following work in progress:

SMAW in the 2F position for the OBG bike path weld No.BK004-A2-031-019. The welder is identified as #044511. ZPMC QC is identified as Mr. Yu Zhi Lai. The welding variables recorded by QC appear to comply with WPS-B-P-2114-PLUG.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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ZPMC personnel performing SMAW for weld joint BK004-AS3-0359-019/020 at 3F position on Bike path at bay#8



12/26/2010 09:34

ZPMC personnel performing SMAW for repair weld joint OBW12-001 at 4G position on segment 12AW to 12BW at trial assembly area



12/26/2010 09:13

ZPMC personnel performing SMAW for weld joint SEG3005M-090 at 2G position on segment 12BW at trial assembly area



12/26/2010 15:17

ZPMC personnel performing SMAW plug welding at 2F position for weld joint BK004A2-031-019 on bike path at bay#10



12/26/2010 09:07

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Bera,Subhasis

Quality Assurance Inspector

Reviewed By: Dsouza,Christopher

QA Reviewer